FORREST Technical Coatings

19P Series Technical Data Sheet

PRODUCT DESCRIPTION

FORREST's two-part epoxy primer is formulated to protect surfaces exposed to chemicals, solvents or abrasion. FORREST epoxies are suitable for application on new equipment, structural steel and concrete. They are also excellent maintenance coatings for properly prepared substrates.

Color: Gray
Sheen: Semi-Gloss

PRODUCT AND PERFORMANCE DATA

Product Data

Property	Result
Volume solids (%)	64 ± 2
Weight solids (%)	80 ± 2
VOC	314 g/L 2.6 lb/gal
Recommended dry film thickness	2 – 4.5 mils
Recommended wet film thickness	3 – 7 mils
Theoretical Coverage (1.0 mil)	1026.6 ft²/gal
Dry to Handle (77°F @ 50% RH)	4 – 6 hours
Recoat	1 – 2 hours or overnight
Full Cure	1 week
Pot Life @ 77°F	8-10 hours

Performance Data

Test Method	Standard	Result
Gloss @ 60°	ASTM D523-14	80+
Adhesion	ASTM D3359	5B
Impact Resistance	ASTM D2794-90	>120 in-lbs
Pencil Hardness	ASTM D3363	3H

**Testing was performed on fully cured 19P955.*

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SURFACE PREPARATION

Pre-cleaning:
Clean all surfaces to be coated in accordance with SSPC-SP-1, Solvent Cleaning prior to additional surface preparation or coating application. Surface must be clean, dry and free of any dirt, dust, oil, and all other visible contaminates.

Surface Preparation

Recommended	SSPC SP 6 (Commercial Blast Cleaning)
Minimum	SSPC SP 2 or SP 3 (Hand or Power Tool Cleaning)

MIXING AND THINNING

Before application, mechanically mix for 15 minutes at the ratio of ***1:1***. Allow mixture to stand for 45 minutes before using.

Catalyst B Semi-gloss	10K011	Volume Solids: 44% ± 2	VOC: 546 g/l, 4.6 lb/gal

Mix Directions
Stir thoroughly before and occasionally during use.

Thinning Directions
Product packaged ready to apply. If needed thin up to 10% maximum with Forrest's 81T004, Epoxy Thinner.

APPLICATION

Application Parameters

Relative Humidity	50 % ±10
Minimum Temperature	50°F (10°C)
Maximum Temperature	80°F (27°C)

**The application temperature and substrate temperature should be at minimum 5°F above the dew point.*

Curing Schedule	Alkyd	Polyurethane or Epoxy	Water Base
Dry to topcoat	overnight	overnight	overnight

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Force Cure Schedule

Temperature	200°F (93°C)
Time	15 minutes

Application methods
The product can be applied by

Spray
Airless spray: 0.013” - 0.021”

Conventional spray: 1.8mm – 2.4mm

Brush/Roll Use a brush and/or roller cover recommended for EPOXY, thinners in this product may destroy insufficient applicator and cause damage to your finish.

STORAGE

The product must be stored in accordance with local and national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 73°F (23 °C) = at least 12 months *

*When kept in recommended storage condition and original unopened containers.

CAUTION
Adequate health and safety precautions should be observed during storage, handling, use and curing periods.
READ SAFETY DATA SHEETS BEFORE USING THIS PRODUCT

DISCLAIMER

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstances are we liable for incidental or consequential damages.

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